

Date: Wednesday, 9/12/2007 12:13:18 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 34598B		
Estimate Number	: 10339		
P.O. Number	: N/A	Part Number	: D2658
This Issue	: 9/12/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2658 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 34484B	Drawing Revision	: D
	Type : LARGE FAB ASSY	Material	: N/A
Written By	:	Due Date	: 9/30/2007
Checked & Approved By	: <u>07.09.12</u>	Qty:	30 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-08-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S12GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 0.1197 sf(s)/Unit Total: 3.5910 sf(s)
 1010/1025/A21/6aA SHEET
 12 GAUGE: 100" THK
 Batch: M 164288 B 07-09-17

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2858
 Dwg Rev: D B 07-09-17
 Prog Rev: D

2-Deburr if necessary B 07-09-17



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

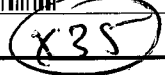
4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/09/17

corrects



5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 1-Deburr as required.

2-Bend on CNC brake using DT8254 Identify as D2658

SB 07/09/17



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:18 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 34598B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

In A (09/19)

(35)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/18

(35)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(35)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/19

Job Completion



07/09/18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

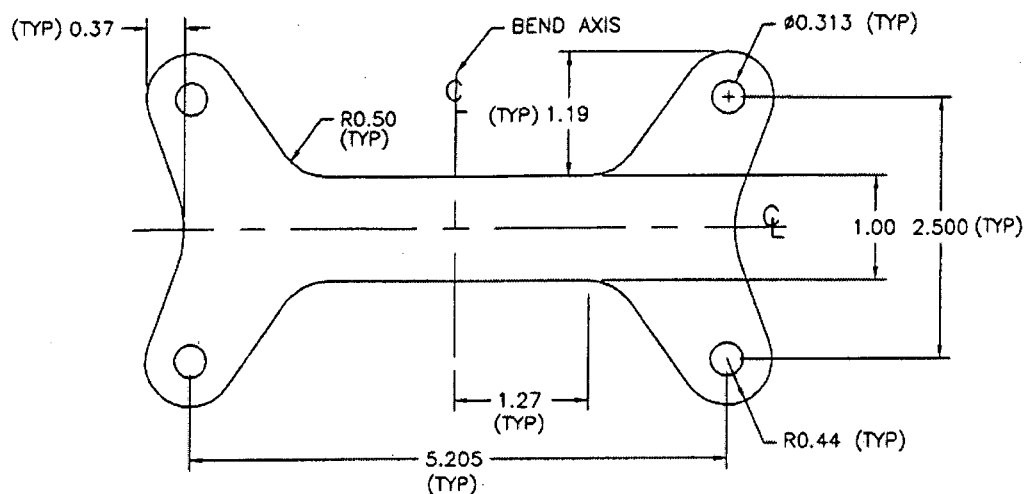
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

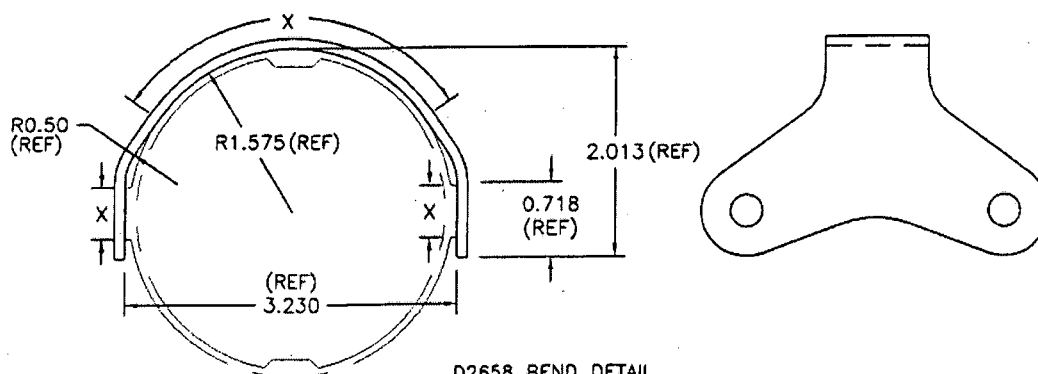


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34598B